

Work Order ID 81254

81254

Page 1

March-12-12 1:54:07 PM

Item ID: D3929-042

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Gusset Assembly

Stop

NS2

Start Date: 12/03/2012 Start Qty: 6.00

6

Cust Item ID:

Required Date: 16/03/2012 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 12/03/12 Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3929

A

100

0.00

100

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3929

Dwg Rev: A

Prog Rev: A

2-Deburr if necessary

B/L-3-20

(7)

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

B/L-3-20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

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Revision ID:

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Item Name: Gusset Assembly

Start Date: 12/03/2012 Start Qty: 6.00

6

Cust Item ID:

Required Date: 16/03/2012 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

Quality Control

12/03/21

SM

140

0.00

140

Large Fab

Memo

0.00

Large Fab

Weld bushings D3907-1 as per dwg D3929

316L rod batch: M115778

12.04.09 ⑦

150

QC9- Inspect visual per QSI004- Fusion Welds

0.00

150

QC

Memo

0.00

Quality Control

12.04.10

7 0

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Revision ID:
Item Name: Gusset Assembly

Accept

N900040100

Setup Start ***NS1***
Stop ***NS2***

Start Date: 12/03/2012 Start Qty: 6.00 ***6***
Required Date: 16/03/2012 Req'd Qty: 6.00 ***6***

Cust Item ID:
Customer:

Reference:

Approvals: Process Plan: Date: Tooling: Date:
QC: Date: SPC (Y/N): Date:

Run Start ***NR1***
Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 *160* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00		5.2/6.10		(X)			
170 *170* Packaging Packaging	Identify as per dwg & Stock Location: B-C Memo	0.00 0.00							
180 *180* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							

12.04.10 (7)

12/4/10

12-04-10

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Picklist Print

March-12-12 1:54:11 PM

Page 1

Work Order ID: 81254

81254

Parent Item: D3929-042

D3929-042

Parent Item Name: Gusset Assembly

Start Date: 12/03/2012

Required Date: 16/03/2012

Start Qty: 6.00

Required Qty: 6.00

Comments:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S11GA		Purchased	No			100	sf	31.1000	0.45	2.842105			

M304S11GA

304/316 0.125 Sheet

**

B12-3-20

Location

Loc Qty

Loc Code

MAT020

31.1

120243

26

120604

5.1

120243

(7)

D3907-1

Manufactured No

130

Each

43.0000

2

12

D3907-1

Bushing

**

Location

Loc Qty

Loc Code

WA

43

73008

3

79121

40

B1470

(11)
(3)

12-04-09

W/O:		WORK ORDER CHANGES					
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Dart Aerospace Ltd

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ITEM	QTY -041	QTY -042	P/N	DESCRIPTION
1	X		D3929-041	GUSSET ASSEMBLY
2		X	D3929-042	GUSSET ASSEMBLY
11	2	2	D3907-1	BUSHING
12	1	1	D3929-1	SUPPORT GUSSET

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 81254 MLJ

12/03/12

D3929-041 GUSSET ASSEMBLY

D3929-042 GUSSET ASSEMBLY

RELEASED
8/6/12

- NOTES:
1) MATERIAL: N/A
2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3929-04X" USING FINE POINT PERMANENT INK MARKER
7) WEIGHT: 0.73 lbs EACH
8) WELDING: PER DART QSI 004

A	NEW ISSUE	MB	09.04.03
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	09.04.03		

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D3929	REV. A SHEET 1 OF 3
TITLE GUSSET ASSEMBLY	SCALE NTS
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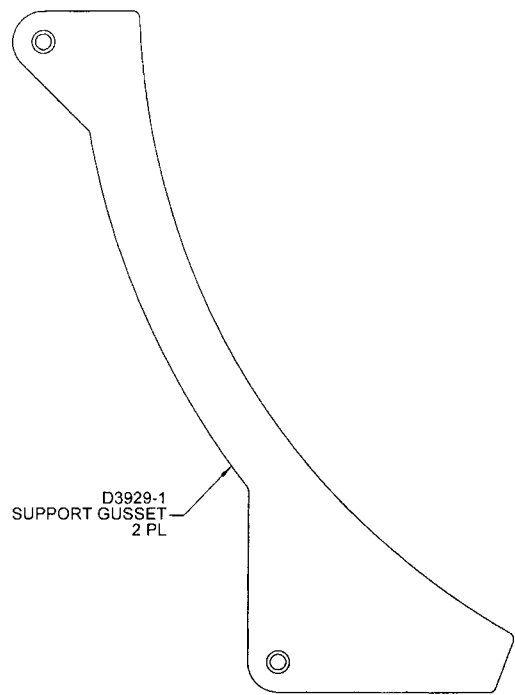
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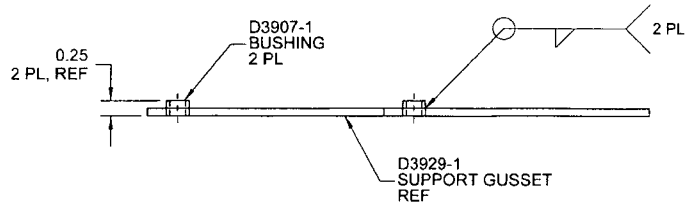
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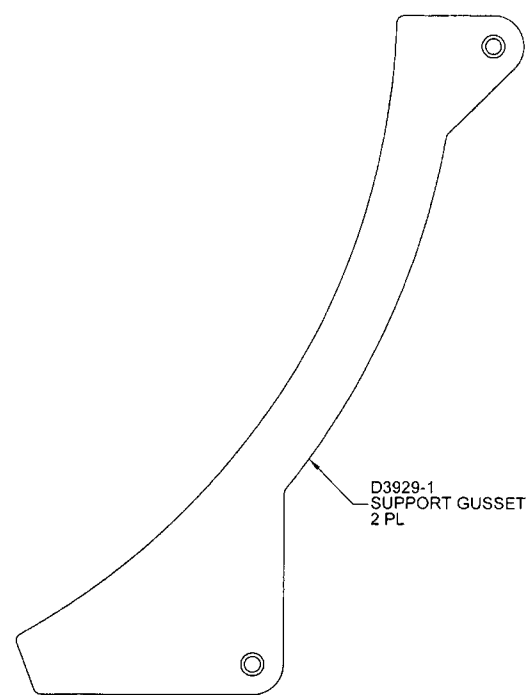
NOTE: Date & initial all entries



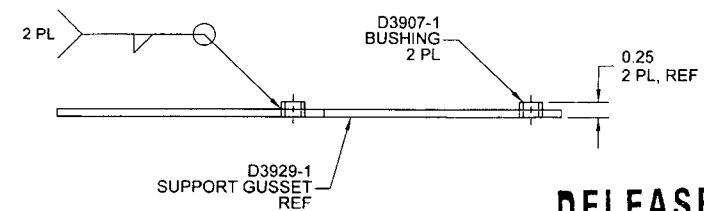
D3929-1
SUPPORT GUSSET
2 PL



D3929-041 GUSSET ASSEMBLY



D3929-1
SUPPORT GUSSET
2 PL



D3929-042 GUSSET ASSEMBLY

81254

RELEASED
09/04/22

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D3929	REV. A
MFG. APPR.		TITLE	SHEET 2 OF 3
APPROVED		GUSSET ASSEMBLY	SCALE
DE APPR.			NTS
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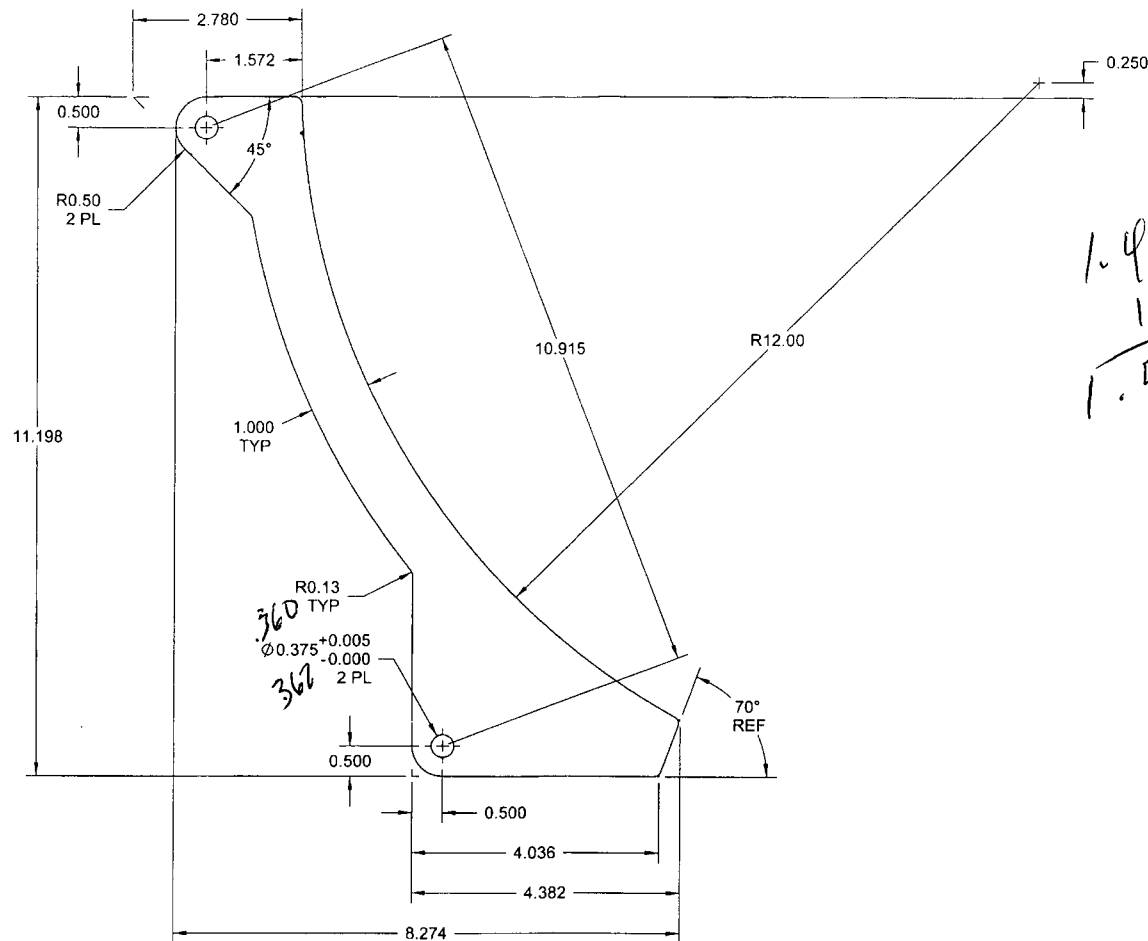
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81254

1.416
183
1.599

183
366
28
16
1

322
183
505

D3929-1 SUPPORT GUSSET

- NOTES:**
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET PER AMS 5513 OR 5524
11 GAUGE (0.125 THICK)
REF. DART SPEC. M304S11GA
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.72 lbs

RELEASED
09/04/22

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DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D3929	REV. A
MFG. APPR.		TITLE	SHEET 3 OF 3
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